Work Order ID 120773

Wednesday, June 11, 2014 10:32:27 AM

120773

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft, Center Ceiling Panel

Start Date: 7/02/14 **Start Qty:** 1.00 *1*

Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** 14-6-11 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D4634	F

100

100

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING — 0.00

Memo Cut Blanks — 0.00

X1

DAS 07 9-89

14/06/17

105

105

HandThermo

Hand Finishing Thermoforming

Dry Material — 0.00

Memo Dry Sheet as per QSI022 POLYCARBONATE — 0.00

X1

DAS 07 9-89

14/06/17

Temp: 245 deg.

Time IN: 5:00 PM

Time OUT: 6:00 AM

JUN 17 2014

Per.....

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft, Center Ceiling Panel
Start Date: 7/02/14 **Start Qty:** 1.00 *1*
Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89
110	THERMOFORMING MACHINE					X1			
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4634-5 and Folio FTA146								14/06/17
	Dwg. Rev. F								
	Folio Rev. E								
	NOTE: Check moulds prior to using to ensure proper placement of add-ons.								
	Visually inspect for proper formation and texture								
130		0.00							DAS 07 9-89
130	HAND FINISHING THERMOFORMING					X1			
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								14/06/23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft, Center Ceiling Panel
Start Date: 7/02/14 **Start Qty:** 1.00 *1*
Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	~~QC~~- Inspect dimensions to drawing Dimensional Inspection QC2 **Memo** Fill out Inspection Sheet Rev A	0.00 0.00							
150 *150* QC Quality Control	~~QC~~- Inspect part completeness to step on W/O QC **Memo**	0.00 0.00							
160 *160* Packaging Packaging	Packaging **Memo**	0.00 0.00				1			

DAS 27 9-89 14/7/29
DAS 16 9-89 14/7/29
Section MF
SHP 14/7/29

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
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Supplier	☐									
Training	☐									
Transport	☐									
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☐ Wrong Stock Pulled

☐ Other

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*
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Item Name: Aft, Center Ceiling Panel
Start Date: 7/02/14 **Start Qty:** 1.00 *1*
Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*
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Cust Item ID:
Customer:

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	**Memo**	0.00				_____	14/7/30 MF 14-7-29		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
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☐ Wrong Stock Pulled
☐ Other

Picklist Print

Wednesday, June 11, 2014 10:32:27 AM

Work Order ID: 120773

120773

Parent Item: D4634-5

D4634-5

Parent Item Name: Aft, Center Ceiling Panel

Start Date: 7/02/14 **Required Date:** 7/02/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg. Update, Material Change 13/12/18 DL IPP Rev. D 14/01/20 Dwg Update DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,148.443	17.33	18			DAS 07 9-89
MLEXS.093-F6006-07									**				
GE PLASTICS LEXAN SHEET (Grey)													

14/06/17

Location	Loc Qty	Loc Code	
MAT023	1148.44332		
114459	229.26		
123105	38		
124501	543.5		
m128668	181.35		
m129014	156.33332		

129471

18 sq ft.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

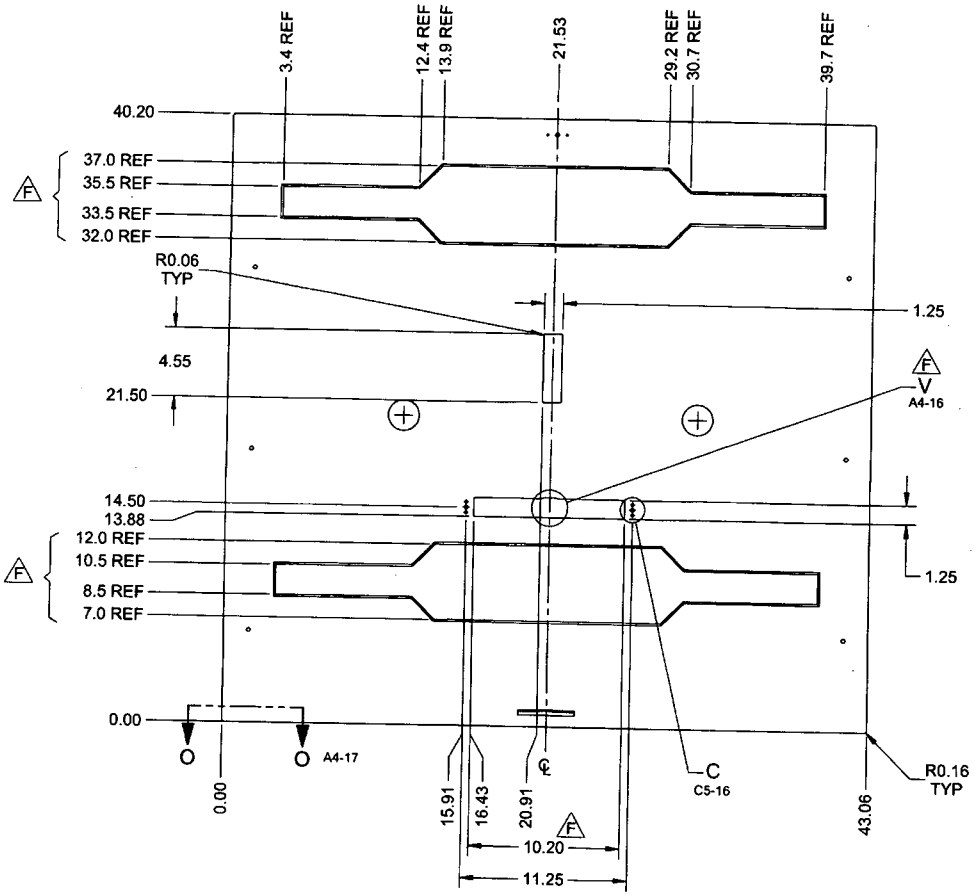
FAULT CATEGORY

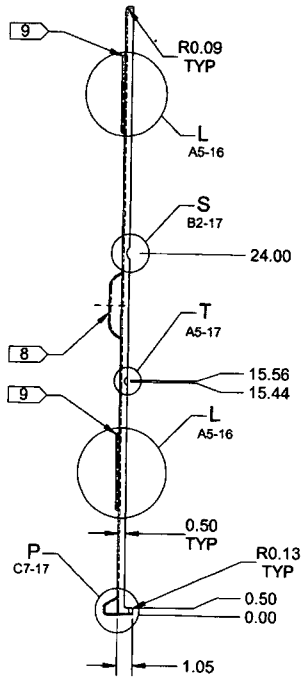
Landing Gear

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other





SHOP COPY
RELEASED
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITHIN
WORK
NO. 120773MP
14-6-11

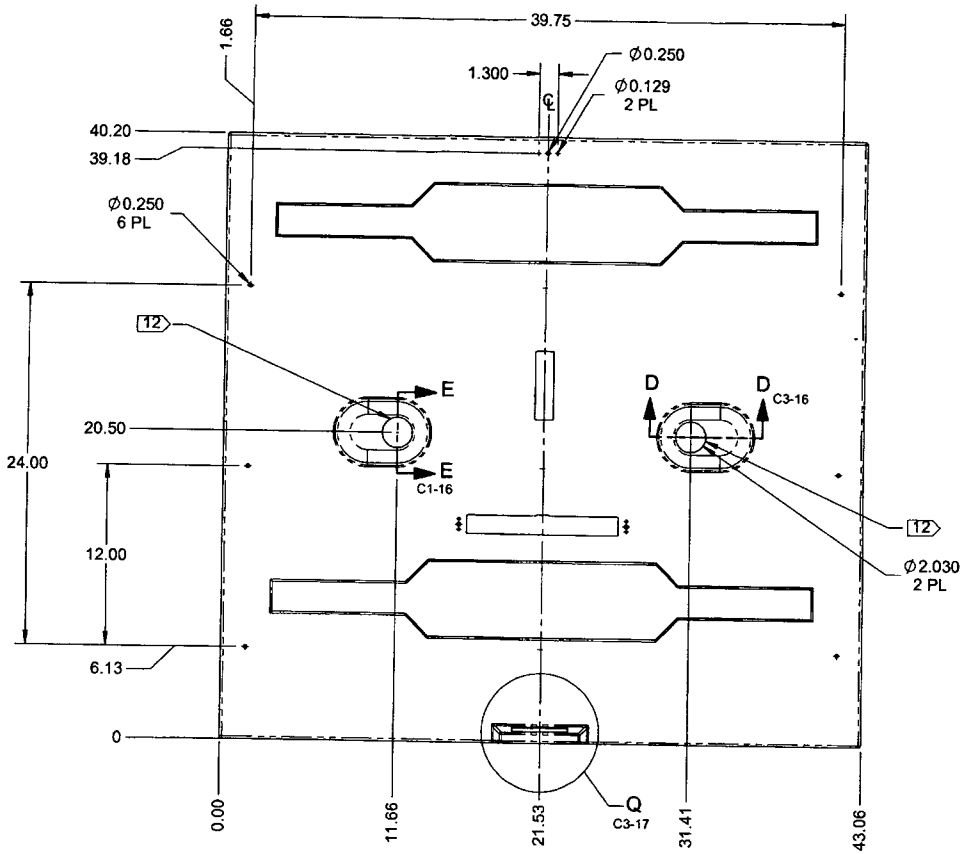
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 7.39 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-5 PER TOOL DT9838
11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE ⌀2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-5 AFT, CENTER CEILING PANEL

RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4634 REV. F
MFG. APPR.		SHEET 14 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.02.03	

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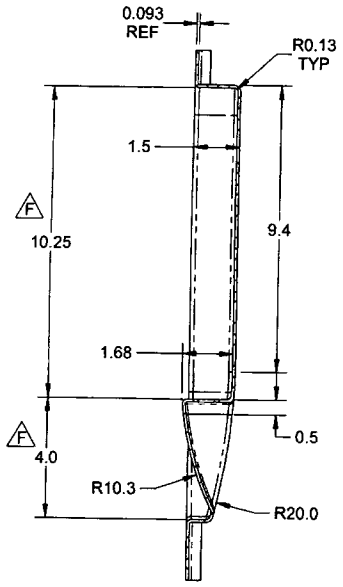


D4634-5 AFT, CENTER CEILING PANEL
AUXILIARY VIEW

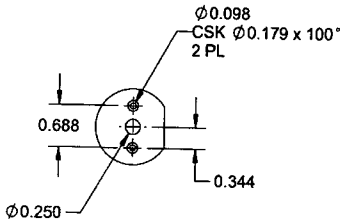
RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. F
MFG. APPR.		D4634	SHEET 15 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.02.03		

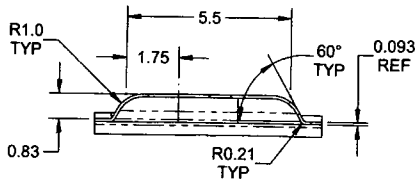
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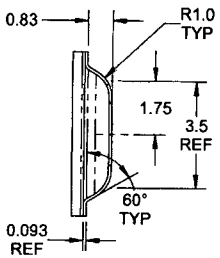
SECTION G-G C5-11
SCALE 4X



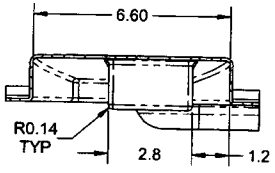
DETAIL C B7-10 B4-12 B4-14
SCALE 4X



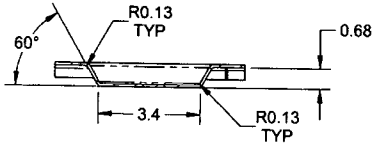
SECTION D-D B6-11 C4-13 C4-15
SCALE 2X



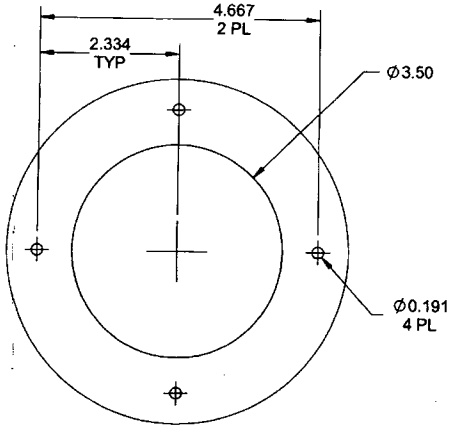
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SCALE 4X



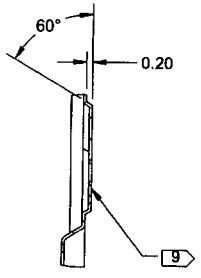
SECTION H-H C5-11
SCALE 2X



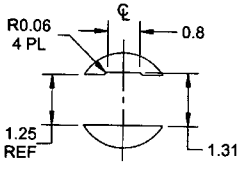
SECTION J-J B6-13
SCALE 2X



DETAIL B B7-10
SCALE 4X
2 PL



DETAIL L B2-13 C2-13 B2-14 C2-14
SCALE 4X
TYP

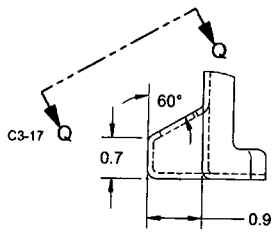


(F) **DETAIL V** C4-10 B4-12 C4-14
SCALE 2X
SIMILAR

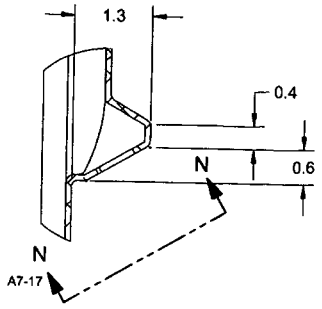
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2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4634 REV. F
CHECKED	DC	SHEET 16 OF 17
MFG. APPR.		TITLE CENTER CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.02.03	

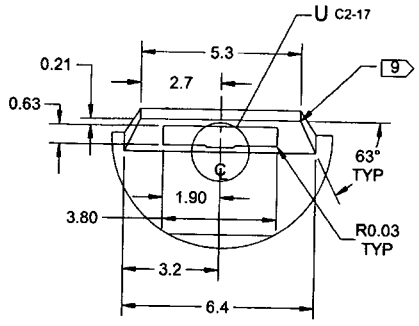
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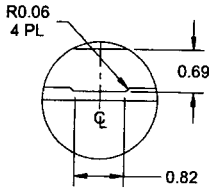
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SCALE 2X



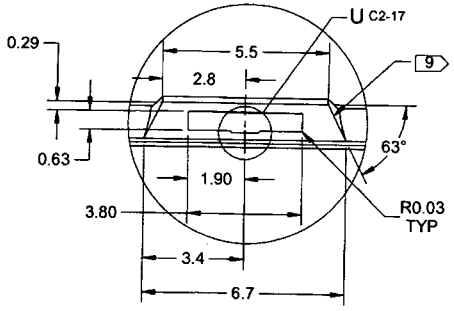
DETAIL M C3-10
SCALE 2X



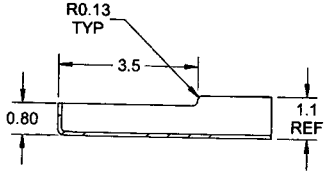
DETAIL Q B4-15 D8-17
SCALE 0.5X



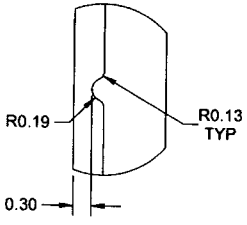
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SCALE 0.5X



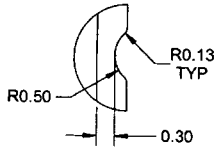
DETAIL N C5-17 B4-15
SCALE 0.5X



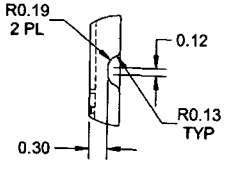
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

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DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. REV. F
CHECKED	SC	D4634 SHEET 17 OF 17
MFG. APPR.		TITLE SCALE
APPROVED		CENTER CEILING PANELS NTS
DE APPR.		
DATE	14.02.03	

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DART AEROSPACE LTD

Description: Aft Center Ceiling Panel		**Work Order:**	B120773
Inspection Drawing: 4634-5	**Rev:** F	**Part Number:**	TJ4634-5

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.20	±0.030	10.25	✓		S. Fab - 21	
11.25	±0.030	11.25	✓		"	
15.91	±0.030	15.96	✓		"	
1.25	±0.030	1.243	✓		S Fab - 08	
4.55	±0.030	4.556	✓		"	
21.50	±0.030	21.50	✓		S Fab - 21	
13.88	±0.030	13.90	✓		"	
1.25	±0.030	1.239	✓		S Fab - 08	
21.53	±0.030	21.55	✓		S. Fab - 21	
12.00	±0.030	12.00	✓		"	
24.00	±0.030	24.00	✓		"	
20.50	±0.030	20.50	✓		"	
Ø 0.250	+0.005 -0.001	.256	✓		S Fab - 08	
39.75	±0.030	39.75	✓		S Fab. 21	
1.300	±0.010	1.304	✓		S Fab - 08	
Ø 0.129	+0.005 -0.001	.128	✓		S. Fab - 08	
Ø 0.250	+0.005 -0.001	0.251	✓		S Fab - 08	
11.66	±0.030	11.66	✓		S Fab - 21	
31.41	±0.030	31.41	✓		S Fab - 08	
Ø 2.030	+0.012 -0.001	2.035	✓		"	
3.80	±0.030	3.816	✓		"	
0.63	±0.030	0.641	✓		"	

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
SMP	DAS 16 9-89	DAS 16 9-89	
Date 14/4/25	Date 14/4/25	Date 14/4/25	Date